

Order ID 116669

4-23-14 8:52:36 AM

\*116669\*

Page 1

Item ID: D2521

Revision ID:

Item Name: Individual Bearpaw

Start Date: 4/23/14 Start Qty: 8.00

Required Date: 5/07/14 Req'd Qty: 8.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 14-04-23

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2521

Rev J

120

\*120\*

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut Blank as per D2521 blank file

0.00

0.00

⑧ mm/EC 14/04/29

130

\*130\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2521 Identify as D2521  
3-Deburr

0.00

0.00

⑧ mm/14/05/09 14/04/29

140

\*140\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

8 mm/14/05/03

**Work Order ID 116669**

April-23-14 8:52:36 AM

**\*116669\***

Page 2

Item ID: D2521

Revision ID:

Item Name: Individual Bearpaw

Start Date: 4/23/14

Start Qty: 8.00

**\*8\***

Required Date: 5/07/14

Req'd Qty: 8.00

**\*8\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

B. a 14/05/06

8

φ

DAS  
08  
9-89

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*160\***

Packaging

Memo

PPP 115364 0.00

Packaging

14/05/06 (8)

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

MLJ 14-05-06

MLJ 14-05-05

# Picklist Print

April-23-14 8:52:38 AM

Page 1

Work Order ID: 116669

\*116669\*

Parent Item: D2521

\*D2521\*

Parent Item Name: Individual Bearpaw

Start Date: 4/23/14

Required Date: 5/07/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No			sf	817.7082		59			
<b>*MUHMWB10*</b>										**			
UHMW 1" Black - 48"x120" Tivar Mfg.#52480104													

Location

Loc Qty

Loc Code

MAT018

817.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

m128011

57

m128267

226

m128668

400

54

mm 14/04/29

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	116669
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2521
<b>Inspection Dwg:</b> D2521 <b>Rev:</b> J		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓		MJP-04	vern
B	0.90	0.96	0.930	✓		...	...
C	0.27	0.330	0.310	✓		6A-01	Dial depth gauge
D	0.470	0.530	0.500	✓		MJP-04	vern
E	21.740	21.760	21.750	✓		...	...
F	0.72	0.780	0.747	✓		MJP-04	vern
G	0.35	0.410	0.375	✓		...	...
H	11.490	11.570	11.500	✓		...	...
I	3.41	3.47	3.425	✓		MJP-04	vern
J	11.790	11.810	11.800	✓		MJP-04	vern
K	9.47	9.53	9.500	✓		MJP-07	Tape
L	7.190	7.210	7.200	✓		CNC-02	vern
M	6.910	6.970	6.927	✓		...	...
N	44.47	44.530	44.500	✓		MJP-07	Tape
O	6.590	6.650	6.625	✓		<del>MJP-07</del> CNC-02	vern
P	0.940	0.980	0.965	✓		MJP-04	vern
Q	18.97	19.03	19.000	✓		MJP-07	Tape
R	0.350	0.410	0.380	✓		MJP-04	vern
S	0.740	0.780	0.755	✓		...	...
T	0.240	0.280	0.247	✓		...	...
U	0.370	0.410	0.381	✓		118-120	deep thread mic
V	0.740	0.780	0.752	✓		...	...
W	0.740	0.780	0.755	✓		MJP-01	vern

<b>Measured by:</b>	<i>[Signature]</i>
<b>Date:</b>	14/05/03

<b>Audited by:</b>	<i>[Signature]</i>	<b>DA#</b>
<b>Date:</b>	14/05/03	08 9-85

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN #	DRAWN BY C.B.	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. <b>D2521</b>	REV. J SHEET 1 OF 3
DATE <b>06.07.28</b>		TITLE <b>205 BEARPAW</b>	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

116669 MJS  
1404-23

RELEASED

06 08-23 [Signature]

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**DART**

DESIGN

#

DRAWN BY

C.B.

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

CHECKED

P

APPROVED

JH

DRAWING NO.

**D2521**

REV. J

SHEET 2 OF 3

DATE

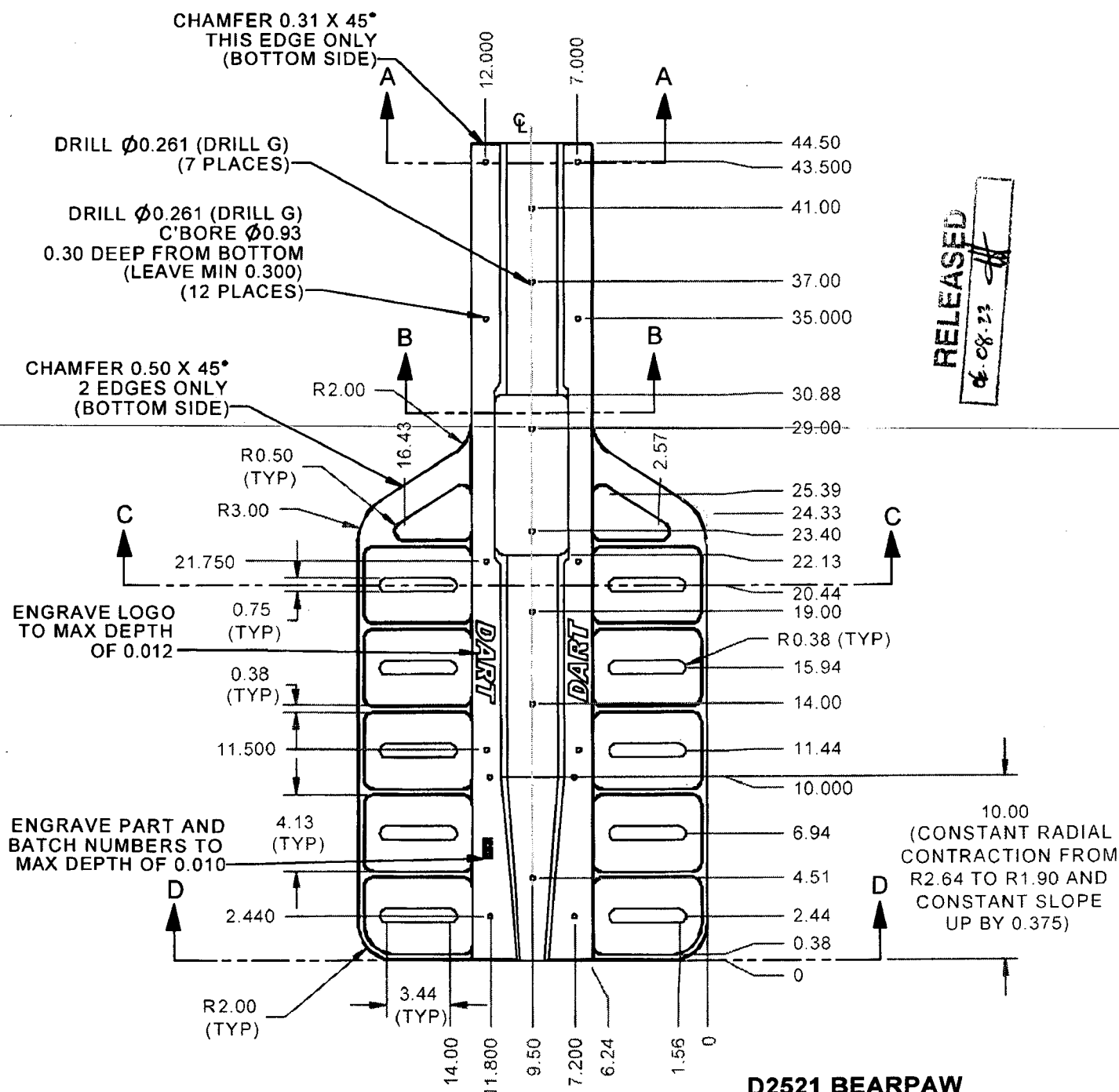
**06.07.28**

TITLE

**205 BEARPAW**

SCALE

1:8

**D2521 BEARPAW****NOTES:**

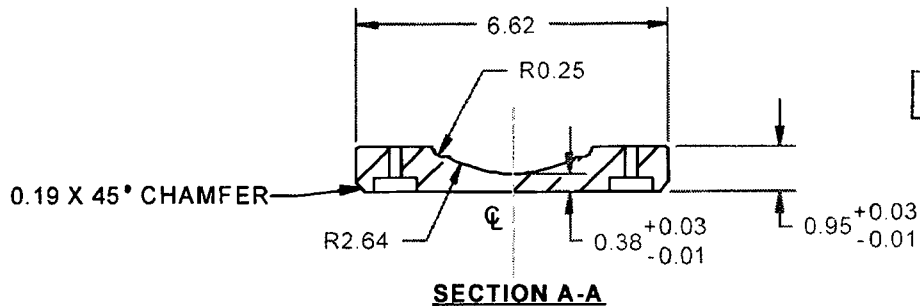
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT  $\varnothing$

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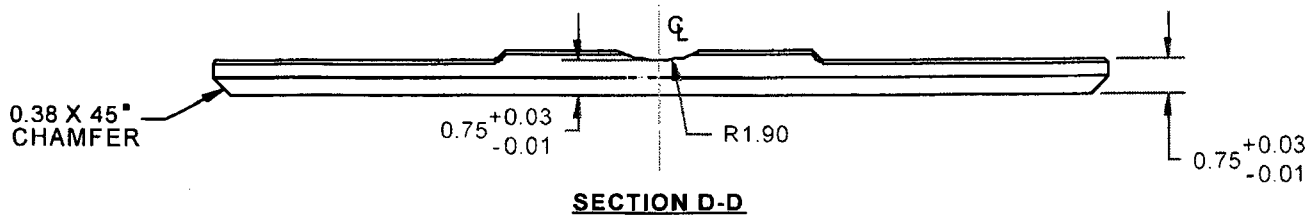
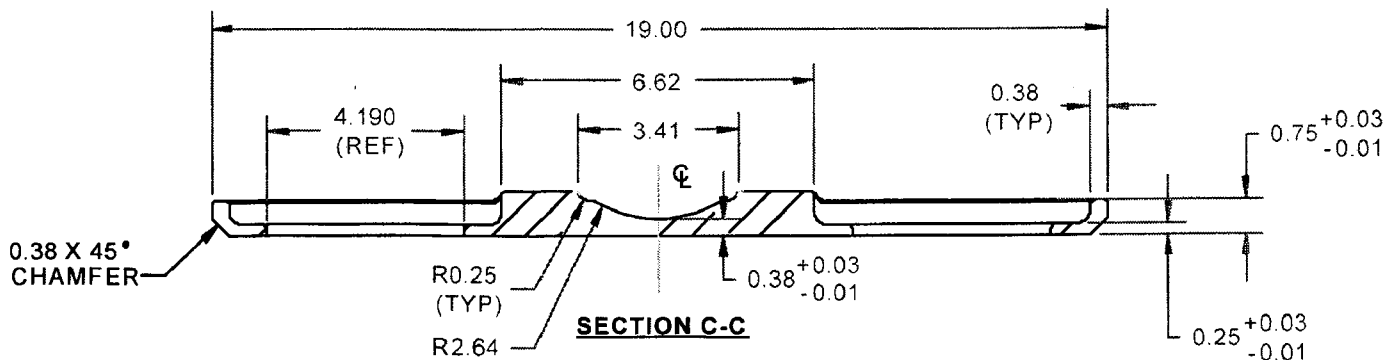
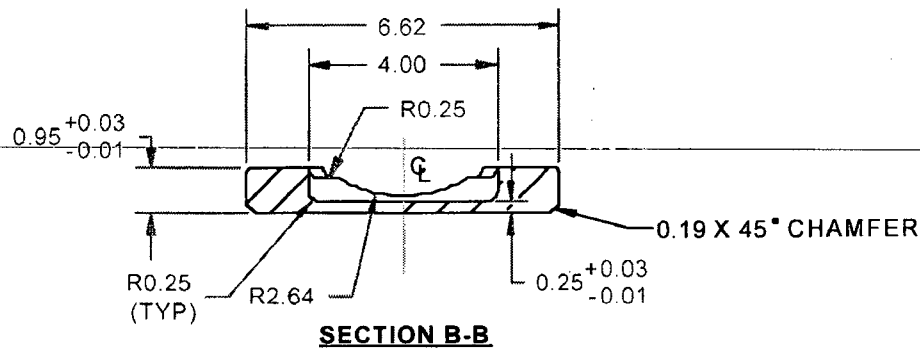
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**DART**

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CHECKED #	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	

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06.08.23

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